

# Work Order ID 51408

August 21, 2009 10:17:29 AM

Page 1

Item ID: D3075-1

Accept

Revision ID: B

Item Name: R44 Bearpaw

Start Date: 8/21/09 Start Qty: 8.00

Required Date: 8/31/09 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: CZ

Date: 09/08/29 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3075	Rev B

110	FLOW WATER JET	0.00
Waterjet	Memo	0.00
FLOW CNC Waterjet	CUT BLANK AS PER FILE D3075-1_BLANK	

B 9-8-26

120	HAAS CNC VERTICAL MACHINING #1	0.00
HAAS I	Memo	0.00
HAAS CNC vertical machine #1	Note: (2) Bearpaw for (1) Kit 11-Inspect material for defects or damage prior to machining 12-Machine as per Folio FA185 and Dwg D3076 Identify as D3075-1113-Deburr	

M.A 09/08/29

130	QC2- Inspect parts off machine FAI/FAIB	0.00
QC	Memo	0.00
Quality Control		

M.A 09/08/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3075-1 PAR #: \_\_\_\_\_ Fault Category: Machined parts NCR: Yes No DQA: [Signature] Date: 05-05-09  
 Acceptable / use as is. QA: N/C Closed: [Signature] Date: 05-05-09

NCR: <u>51408</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.08.31	20	Slight curve in material. Thickness at aft end is 0.918". R.C. Material 1 (had a slight curve on 1 part only.	CP 09.08.31 per Q51042	Acceptable. Remaining thicknesses are OK. Material storage is adequate.	L.A. 09/08/31	DJP 09/09/01	CP 09.08.31 per Q51042	[Signature] 09.08.31

NOTE: Date & initial all entries

**Work Order ID 51408**

August 21, 2009 10:17:29 AM

Page 2

Item ID: D3075-1

Accept

Revision ID: B

Item Name: R44 Bearpaw

Start Date: 8/21/09 Start Qty: 8.00

Required Date: 8/31/09 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

DIT 09/09/01 G

(10)

150

Identify as per dwg & Stock Location: FDP

0.00



Packaging

Memo

0.00

Packaging

51000

129/9/01 (10)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/01 JF

MF 09-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Page 1

August 21, 2009 10:17:29 AM

Work Order ID: 51408

Parent Item: D3075-1RevB

Parent Item Name: R44 Bearpaw

Comments:

Start Date: 8/21/09

Required Date: 8/31/09

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MUHMWB10		Purchased	No			100	sf	392.9220	8.0000			
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UHMW 1" Black



HB 9-8-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

MAT	271.812	
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112186	271.812	
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Main Warehouse

ST	121.11	
----	--------	--

108762	18	
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109186	5	
--------	---	--

110520	8	
--------	---	--

110721	24	
--------	----	--

111354	66.11	
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112186 X 3

108762 X 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 51408
<b>Description:</b> R44 Bearpaw		<b>Part Number:</b> D3075-1
<b>Inspection Dwg:</b> D3075	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.07 x 45°	+0.030/-0.010	0.060x45°	✓			
B	0.63	+/-0.030	0.628	✓			
C	0.250	+/-0.010	0.251	✓			
D	0.950	+0.030/-0.010	0.955	✓			
E	5.50	+/-0.030	5.508	✓			
F	0.25 x 45°	+/-0.030	0.270x45°	✓			
G	0.900	+/-0.010	0.895	✓			
H	0.375	+/-0.010	0.374	✓			
I	1.30	+/-0.030	1.300	✓			
J	5.70	+/-0.030	5.70	✓			
K	0.37	+/-0.030	0.377	✓			
L	3.600	+/-0.010	3.604	✓			
M	0.260	+0.005/-0.000	0.260	✓			
N	0.93	+/-0.030	0.930	✓			
O	0.30	+0.030/-0.000	0.307	✓			
P	1.08 0.94	+/-0.030	0.935	✓			CP 05.08.31
Q	5.870	+/-0.010	5.870	✓			
R	10.14	+/-0.030	10.14	✓			
S	2.250	± 0.010	2.250	✓			CP 05.08.31

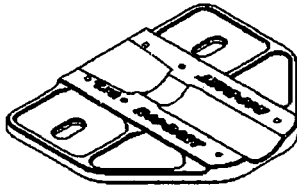
<b>Measured by:</b> M. A	<b>Audited by:</b> DJP	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09/08/29	<b>Date:</b> 09/09/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.13	New Issue P/O D044-662-011	KJ/RF	
B	08.01.16	Dwg Rev updated	KJ/EC/DD	

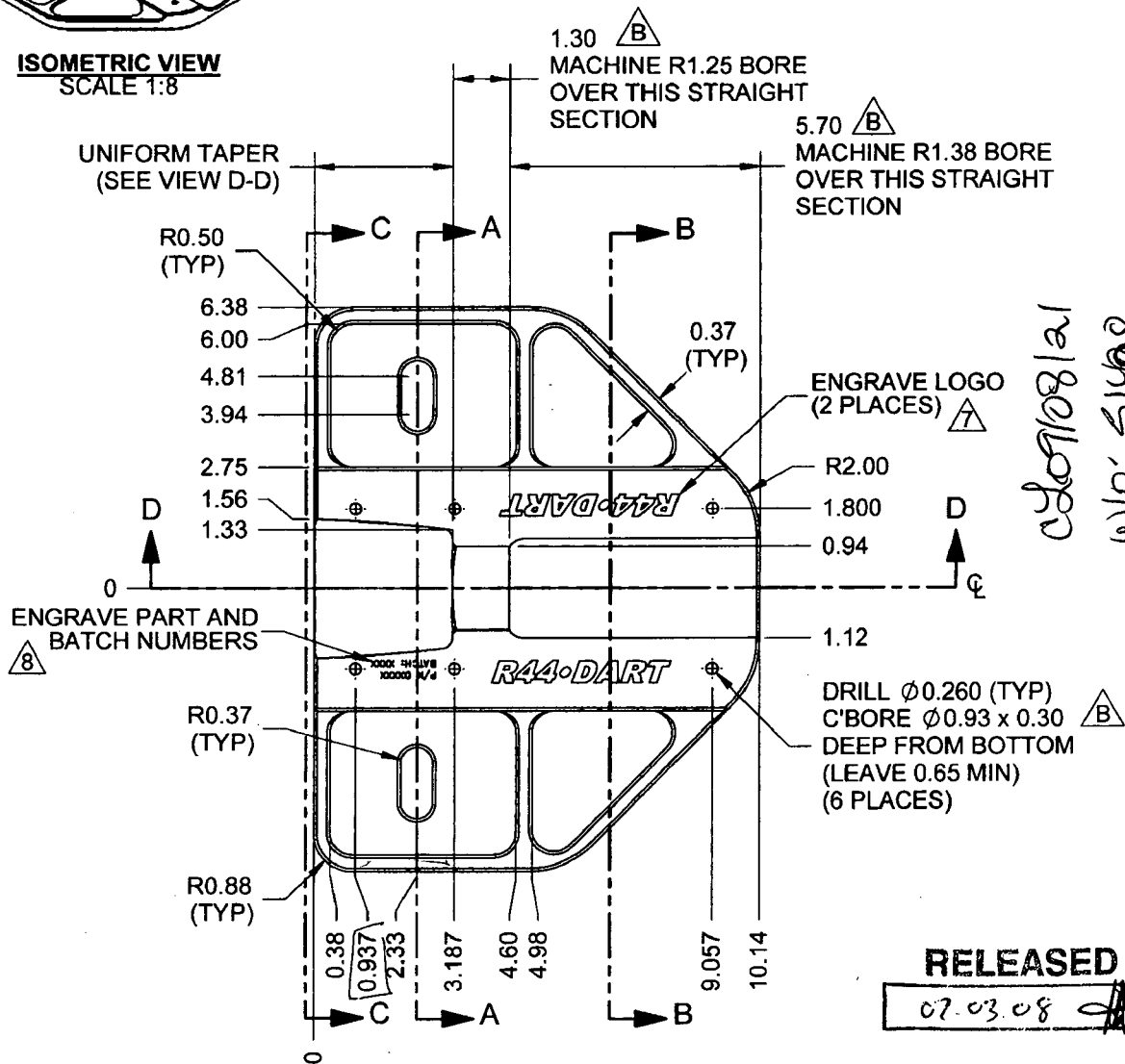


**DART**

DESIGN #	DRAWN BY CB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. <b>D3075</b>	REV. B SHEET 1 OF 2
DATE <b>07.02.27</b>	TITLE <b>R44 BEARPAW</b>		SCALE 1:4
REV	DATE	DESCRIPTION	
A	02.01.04	NEW ISSUE	
B	07.02.27	1.30 WAS 1.60; 5.70 WAS 5.84; $\phi 0.93$ WAS $\phi 0.75$ ; ADD QTY(2) HOLES AT (0.937, $\pm 1.800$ )	



**ISOMETRIC VIEW**  
SCALE 1:8



**D3075-1 BEARPAW**

**NOTES:**

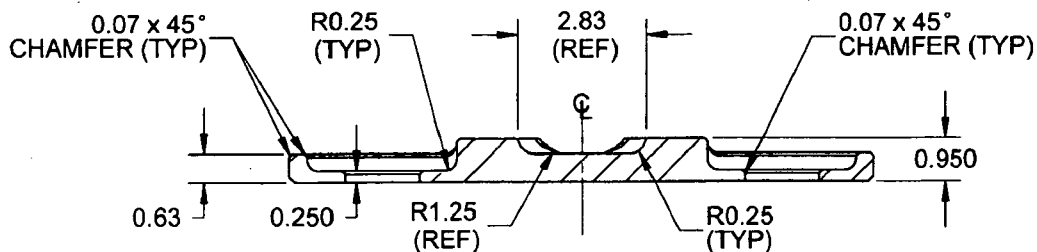
- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) PART IS SYMMETRIC ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) ENGRAVE LOGO TO MAX DEPTH OF 0.012 AT LOCATION SHOWN
- 8) ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010 AT LOCATION SHOWN

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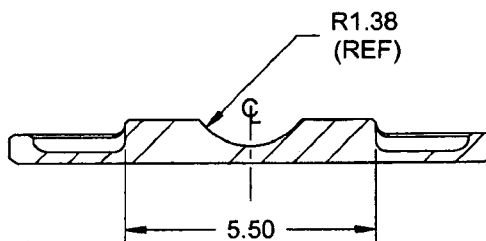
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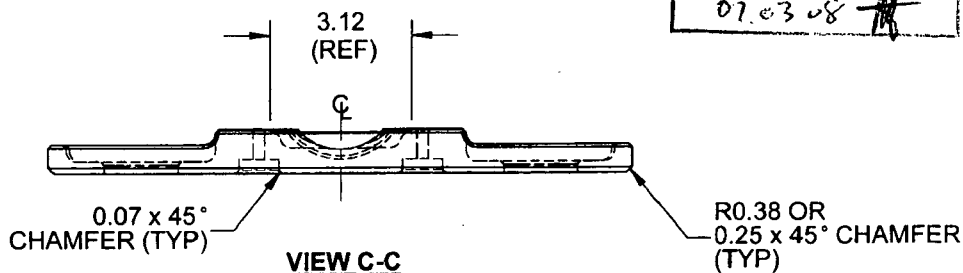
DESIGN <i>[Signature]</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3075</b> REV. B SHEET 2 OF 2
DATE <b>07.02.27</b>	TITLE <b>R44 BEARPAW</b>	SCALE 1:4



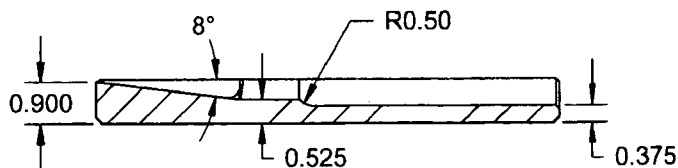
**SECTION A-A**



**SECTION B-B**



**VIEW C-C**



**SECTION D-D**

**RELEASED**

07.03.08 *[Signature]*

*0207/08/21*  
*010: 51408*

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